

Work Order ID 154242

Tuesday, December 06, 2016 4:26:58 PM

154242

Page 1

Item ID: D3584-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 11/30/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: DEC 07 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3584

B

100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

1-Cut to Length as per Dwg D3584
2-Drill Pilot Holes using DT8960 Drill Jig
3-Open pillots to 1.000" as per Dwg D3584
4-Deburr

0.06

110

0.00

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.01

120

0.00

120

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.07

DAS
03
9-892 17-01-18
DJ.2 17-1-18
(2)2 17-1-18
27.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Memo

0.00

Quality Control

DAS
03
8-88

17-1-18

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

LOCATION: LG002

17-1-18

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.03

Quality Control

17/01/23

MF

17-1-18

Picklist Print

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Page 1

Work Order ID: 154242

154242

Parent Item: D3584-1

D3584-1

Parent Item Name: Web

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07.06.12 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2963-125		Manufactured	No			110	Each	16.0000	1	2			
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D2963-125

105 I Beam Extrusion

17-01-17
DH

Location

Loc Qty

Loc Code

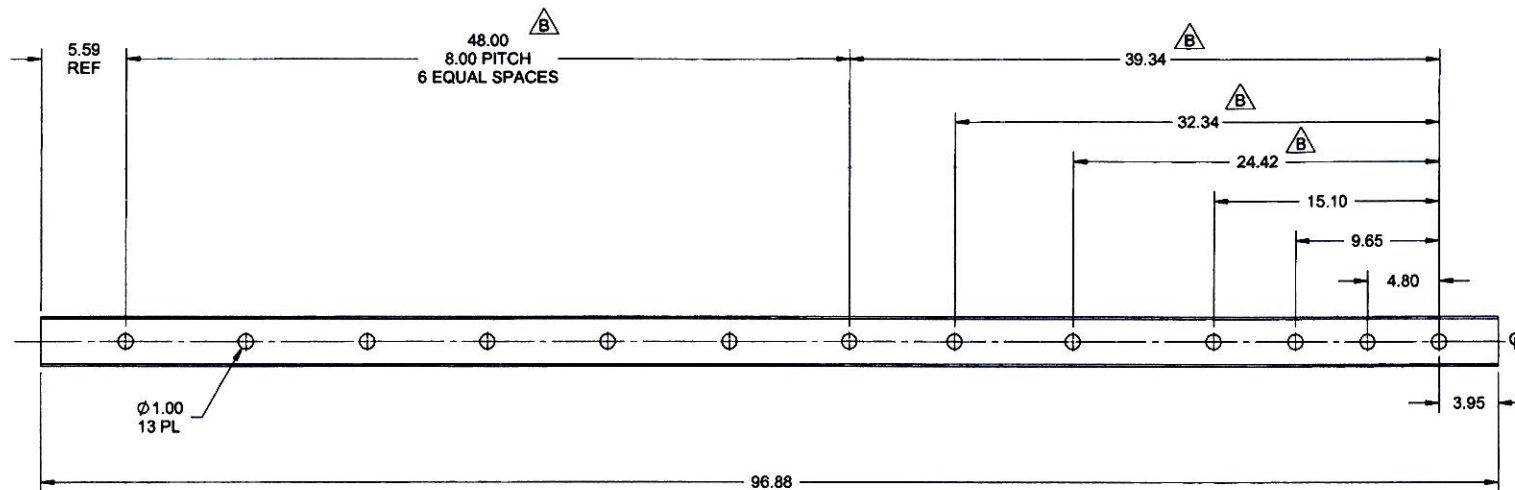
HALL

16

115870

16

2



D3584-1 WEB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

- NOTES:
- 1) MATERIAL: MAKE FROM D2963-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.08 lbs

NO 154242 MWS
1612-07

RELEASED
2015-06-08
EEN 15-651

B	24.42 WAS 23.42, 32.34 WAS 31.34 & (48.00 WAS 56.00 (ZN C3-1 & C8-1); ADDED 39.34	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D3584	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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